

Date: Tuesday, 23/06/2009 11:16:46 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206 A/B HIGH GEAR WEB
Job Number :	48679		
Estimate Number :	10455		
P.O. Number :		Part Number :	D26543
This Issue :	23/06/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2654 REV E1
First Issue :	//	Project Number :	N/A
Previous Run :	46637	Drawing Revision :	E1
	Type :	Material :	
	SKIDTUBES	Due Date :	23/06/2009
Written By :	<u>W</u>	Qty:	10
Checked & Approved By :	<u>W</u>	Um:	Each
Comment :	Est Rev:D 99.02.04 Fixed typo, Changed procedureDM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion '1 Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-5	Web	B-36589

MB 09-06-23

(10x)

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

MB 09-06-23

(10x)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

DD

9-6-24

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MB

09-06-24

(10x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/06/2009 11:16:46 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 48679

Part Number: D26543

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(P)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

[Handwritten signature]

9-6-24

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *SKid tube cell*

MS

09-06-24

(12x)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/24 *[Handwritten signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-06-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

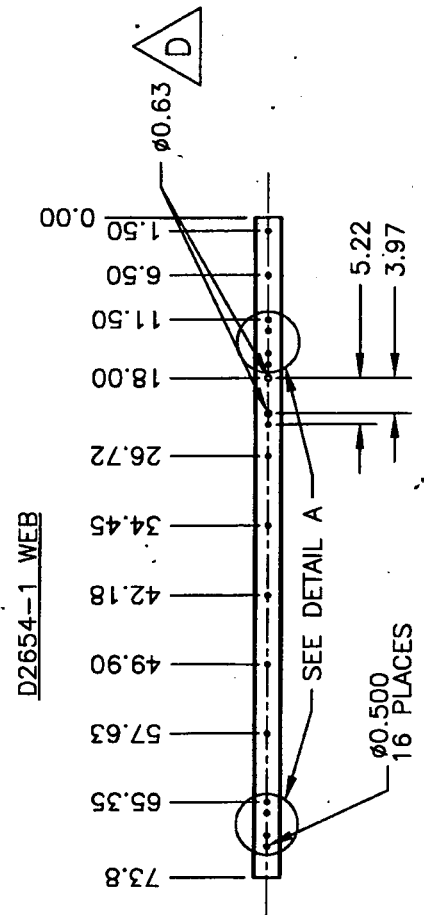
NOTE: Date & initial all entries

DART
DEO ATTACHED

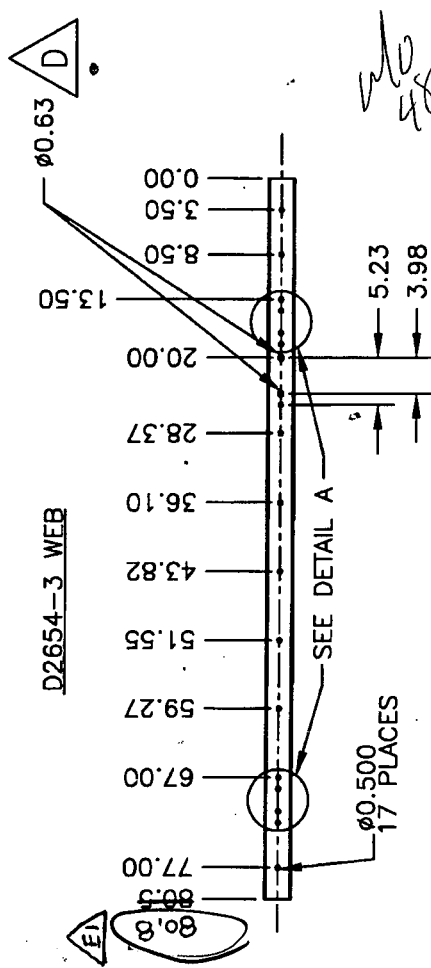


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20
A	97.03.25	NEW ISSUE	
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438	
C	97.10.29	CHANGED HOLE PATTERN	
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$	
E	04.05.26	CHANGE LENGTHS, REFORMAT	
E1	<i>CP</i> 04.08.04	PER TOOLING; 80.8 WAS 80.5	

RELEASED
04.06.22



DETAIL A
SCALE 1:10



MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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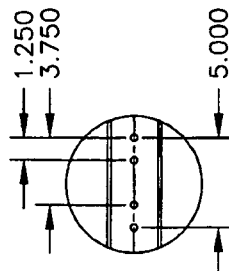


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20

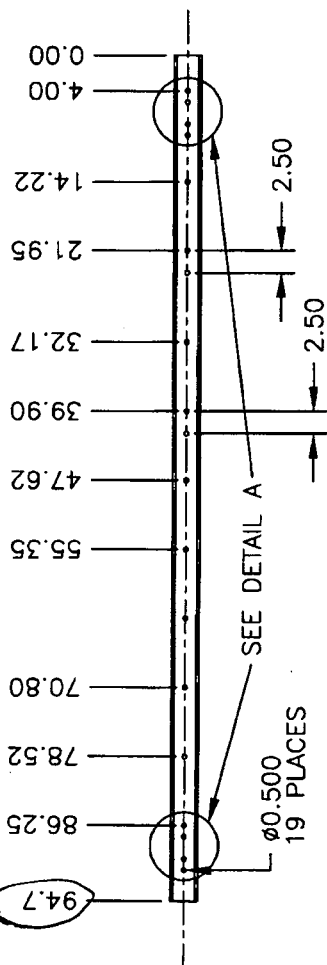
RELEASED
04.06.22

DEO ATTACHED

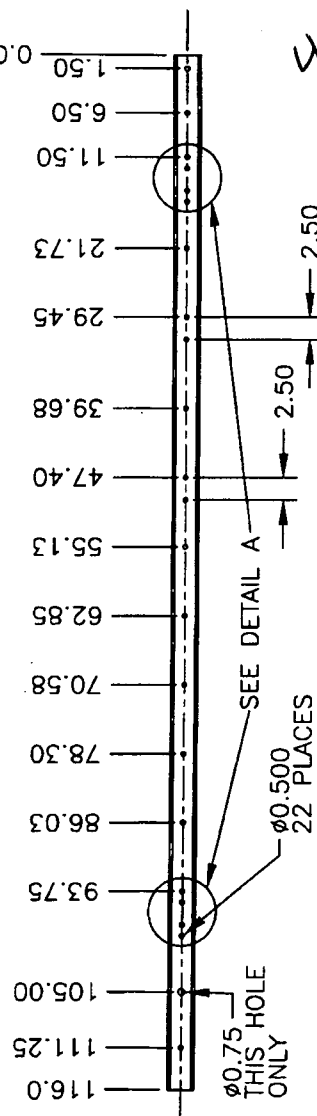
DETAIL A
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



48679

MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

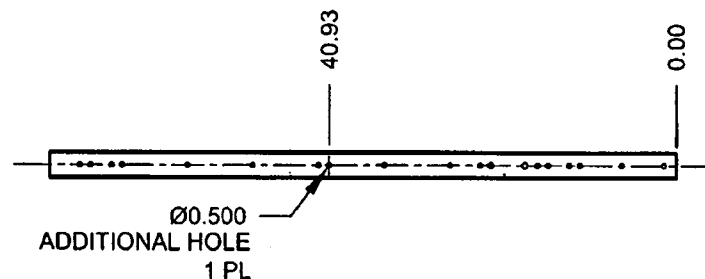
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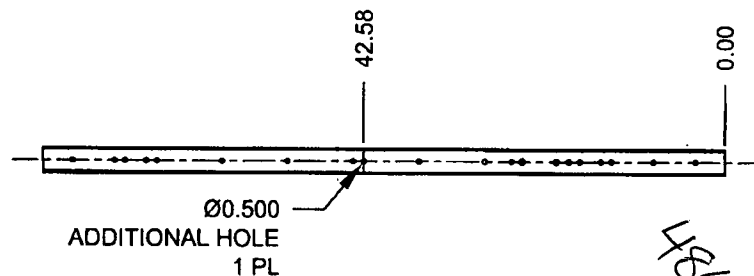
DRAWING NO. D2654	TITLE WEB	REV. E1	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D2654-E-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>PH</i>	MFG. APPR. <i>E</i>	APPROVED <i>MP</i>		DE APPR. <i>#</i>		
DATE 09.03.11	DATE 09.03.11	DATE 09.04.03	DATE 09.04.03		DATE 09.04.03		

DRILL AN ADDITIONAL HOLE IN THE D2654-1 AND D2654-3 WEB AT THE LOCATION INDICATED:

RELEASED
09/04/08 *MP*



D2654-1 WEB



D2654-3 WEB

48679

THE ADDITIONAL HOLE IS REQUIRED FOR COMPATIBILITY WITH D3804-041/-043 SKIDTUBE ASSEMBLIES. ALL OTHER INFORMATION REMAINS UNCHANGED.